

Work Order ID 84942

Tuesday, May 29, 2012 2:43:23 PM

84942

Page 1

Item ID: D3954-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ratchet Lug

Stop ***NS2***

Start Date: 5/29/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/6/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-05-30* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3954

C

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size

*303 1" x 2"**12-08-02**12*

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: *C*Prog Rev: *C*

2-Deburr if necessary

*12**0**Jun 12-7-7*

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Tuesday, May 29, 2012 2:43:23 PM

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Page 2

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12 0 Jm 12-7-7

125

0.00

125

Mill Conv

Memo

0.00

Conventional Milling Machine

Open hole using 0.748" reamer and mill as per Dwg D3954

12-08-02

12

127

QC2- Inspect parts off machine FAI/FAIB

0.00

127

QC

Memo

0.00

Quality Control

12-08-03

12

Work Order ID 84942

Tuesday, May 29, 2012 2:43:23 PM

84942

Page 3

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N900040100

Setup Start ***NS1***

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12

Cust Item ID:

Required Date: 6/6/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Spray Painting per QSI005 4.2

0.00

140

SprayPaint

Memo

0.00

Spray Painting

SPRAY PAINT YELLOW AS PER NOTE 2 ON DWG D3954 (PAGE 3)

150

QC14- Inspect Spray Paint

0.00

150

QC

Memo

0.00

Quality Control

2 2-8-3

12 8

powder coat mt 12-08-08

WAF 12/8/9

12 8 (2P) 12/08/09

*S-12h50
T-320°F
F-1h20*

m116329.

*QC3
5/21/09*

12 x d 11/11/08/09

Work Order ID 84942

Tuesday, May 29, 2012 2:43:23 PM

84942

Page 4

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Cust Item ID:

Required Date: 6/6/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: ~~ST 09~~ **ST 77** 0.00

0.00

160

Packaging

Memo

0.00

Packaging

124

~~12-8-9~~

SP 12-8-10

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/8/13 **JD**mf
12-08-11

Picklist Print

Tuesday, May 29, 2012 2:43:23 PM

Page 1

Work Order ID: 84942

Parent Item: D3954-7

Parent Item Name: Ratchet Lug

Start Date: 5/29/2012

Required Date: 6/6/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B1.000X2.000

Purchased

No

100

f

6.1839

0.5

6.3157895

303 BAR 1" X 2"

Location

Loc Qty

Loc Code

MAT050

6.1839

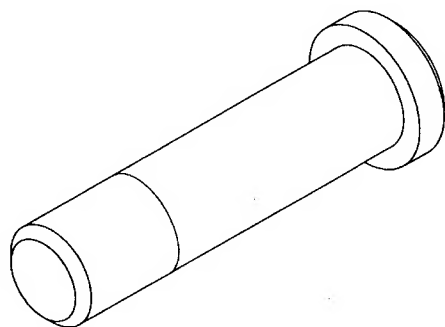
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6.1839

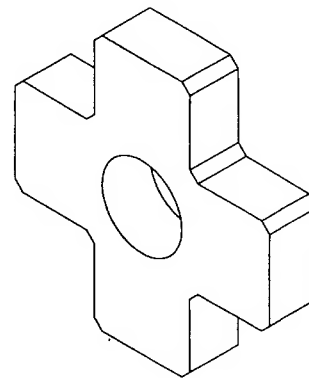
122245

122245

Jun 12-7-7

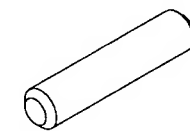


D3954-1 GWT PIN

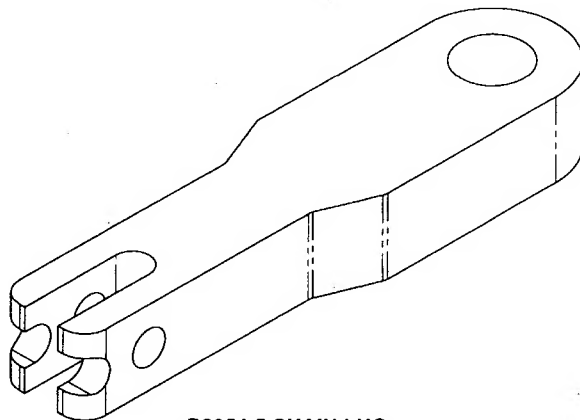


D3954-3 GWT KNOB

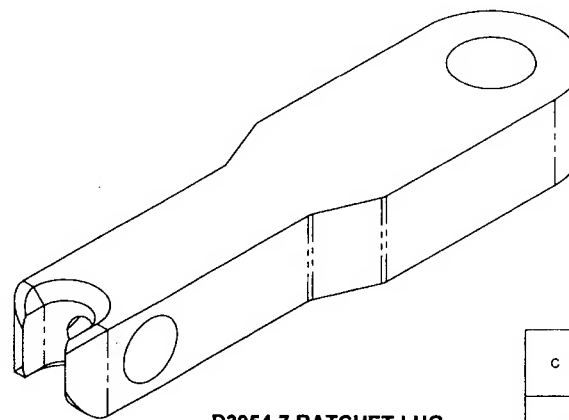
#84940



D3954-9 GWT CHAIN PIN



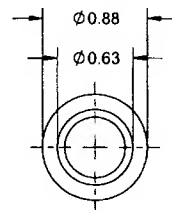
D3954-5 CHAIN LUG



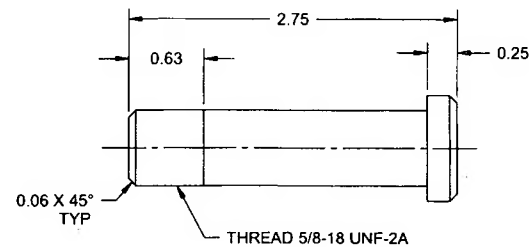
D3954-7 RATCHET LUG

RELEASED
2011-07-29

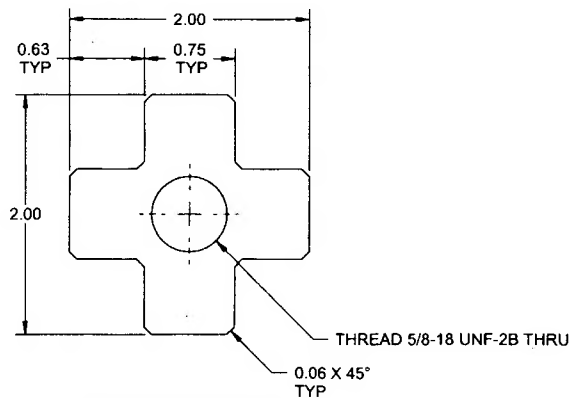
C	MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A8-2). FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A8-2). TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3). D3954-9 NOW A PURCHASED PART (A2/A8-3). REASON: PAR11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.		D3954	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



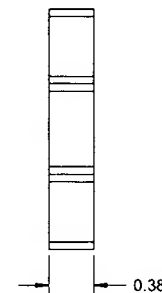
D3954-1 GWT PIN



#84942



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R



-3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S



OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

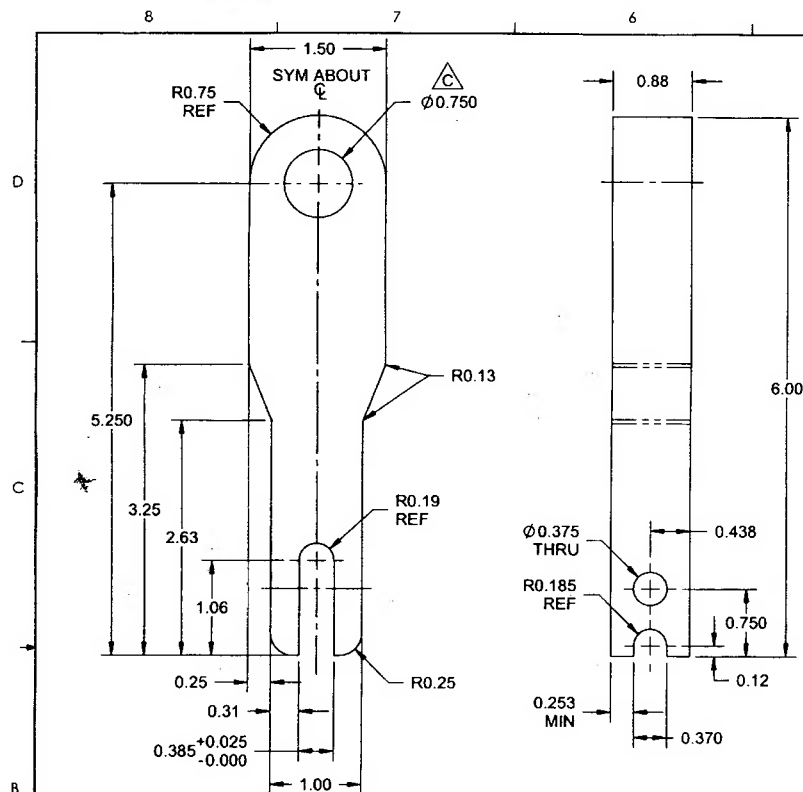
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

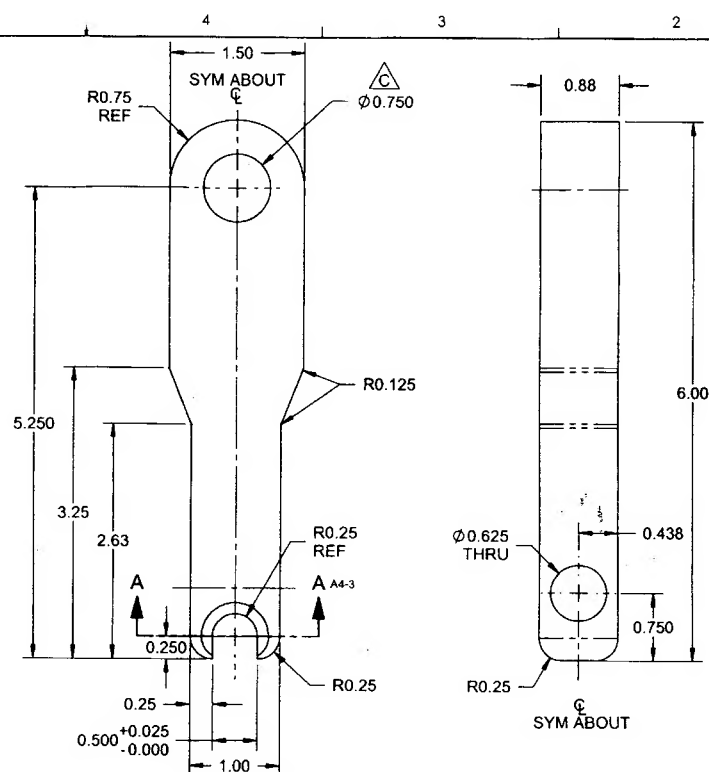
-3: 0.23 lbs

RELEASED
2011-07-29

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

NOTES:

1) MATERIAL:

-5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

-5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B

-9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

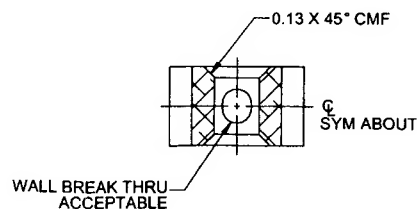
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

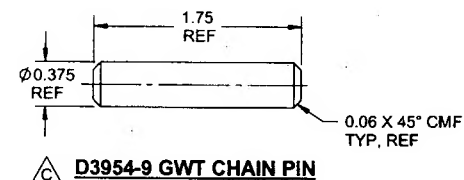
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs REF



SECTION A-A C3-3



DESIGN	AJS/DETOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3954	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries